


Date: Wednesday, 12/7/2005 12:45:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GHW ASSEMBLY R44
Job Number : 25163	
Estimate Number : 10790	
P.O. Number : <i>N/A</i>	Part Number : D044733041
This Issue : 12/7/2005 S.O. No. : <i>N/A</i>	Drawing Number : D3380 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 2408	Material : <i>N/A</i>
Written By : 	Due Date : 1/15/2006
Checked & Approved By : _____	Qty: 10 Um: Each
Comment : Est Rev:B 05.08.19 Revised per CHG002 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Create labels per PPP D044-733-041CHG002

KT 06.12.07

(15)

2.0	D33571	Wheel Shaft R22/R44
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3357-1	Wheel Shaft	<i>B25167</i>

CPL 06.12.07

(10)

3.0	D33575	Lock Shaft R44
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3357-5	Lock Shaft	<i>B25169</i>

CPL 06.12.07

(9)

4.0	D33591	Spacer
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number	Description	Batch
1 D3359-1	Washer	<i>B22467 → 2 B22552 → 7</i>

CPL 06.12.07

(9)

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:45:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW ASSEMBLY R44

Job Number: 25163

Part Number: D044733041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D3379041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

(10)

Pick:

Qty Part Number

Description

Batch

1 D3379-041

Arm Weldment

~~B23506~~ →

CPL 06.12.07

6.0

D33801

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

(9) (10)

Pick:

Qty Part Number

Description

Batch

1 D3380-1

Handle

~~B22469~~

CPL 06.12.07

7.0

D33811

Handel Label



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

(9) (10)

Pick:

Qty Part Number

Description

Batch

1 D3381-1

Label

~~B25805~~

CPL 06.12.07

8.0

D3399041

Wheel Assembly R22/R44



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

(9) (10)

Pick:

Qty Part Number

Description

Batch

1 D3399-041

Wheel Assembly

~~B22458A~~
~~B29916~~ →

CPL 06.12.07

9.0

GP1R

Black Vinyl Grip



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

(9) (10)

Pick:

Qty Part Number

Description

Batch

1 GP-1R

Black Vinyl Grip

~~m16871~~

CPL 06.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:45:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GHW ASSEMBLY R44

Job Number: 25163

Part Number: D044733041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

VA1140

Snap Button



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 VA-1140

Snap Button

M16871

CPL 06.12.07

(9) (10)

11.0

159016

3/4"-16 UNF Thick Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 159-016

3/4"-16 UNF Thick Nut, Span

M16362

CPL 06.12.07

(9) (10)

12.0

178039

1/2"-20UNF Nylon Locknut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 178-039

1/2"-20 UNF Thin Nylon Lock Nut, Span

M16362

CPL 06.12.07

(9) (10)

13.0

LARGE FAB.1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per Dwg D3380

A/R 242 262 Locktite

M102855

CPL 06.12.20

(9)

(9)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12/06/12/20

(9)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

57488 EP 6/12/21

12/06/12/21

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/12/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/12/20	13	103357-1 & D3379-1 scrap. during Assembly the 2 parts seized together due to tolerance build-up.		Scrap & des trap. ↓	Ppl 06/12/20	06/12/20		06/12/20
06/12/20	13	Threads on shaft D3357-1 was are not to Dwg. Rework parts		Rework thread to Dwg.	MB 06/12/20	06/12/20		06/12/20

NOTE: Date & initial all entries

Date: Wednesday, 12/7/2005 12:45:06 PM
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Process Sheet

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Drawing Name: GHW ASSEMBLY R44

Job Number: 25163

Part Number: D044733041

Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

②
12/06/12/22

Job Completion



U 06.12.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

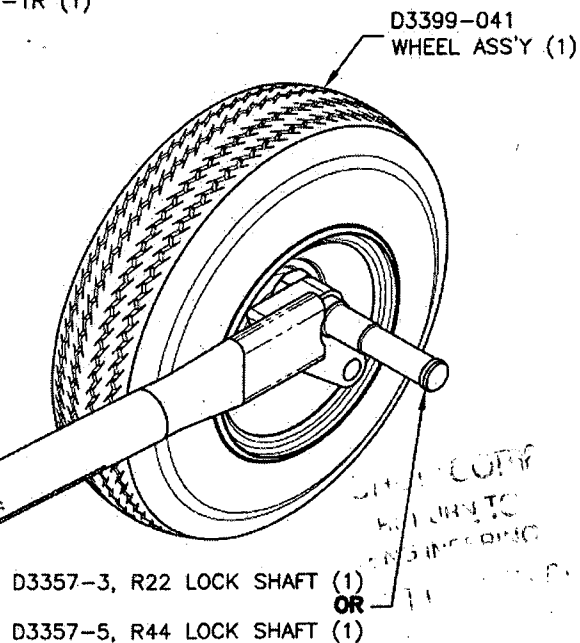
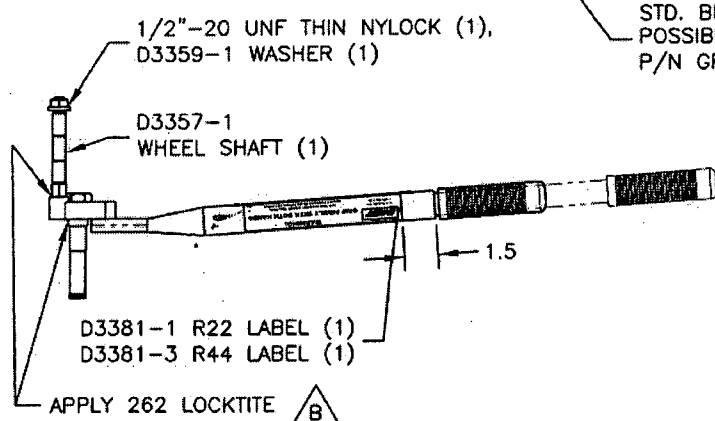
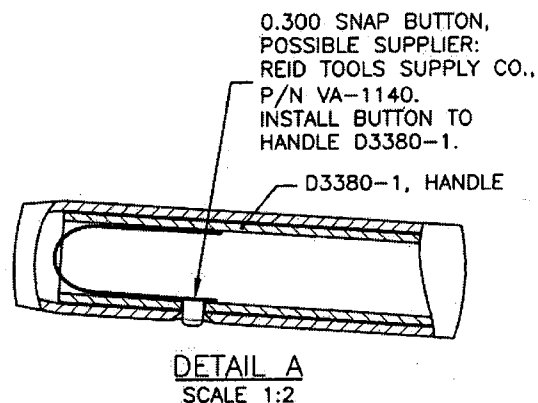
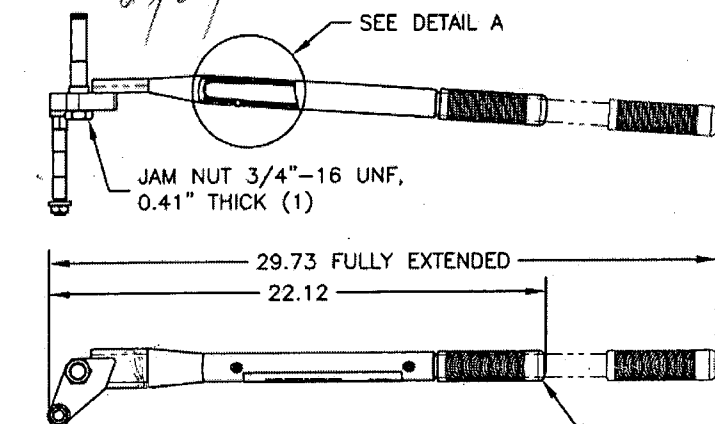
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3380	REV. B SHEET 1 OF 2
DATE 05.07.21		TITLE GROUND HANDLING ASS'Y	SCALE 1:8
A	04.12.13	NEW ISSUE	
B	05.07.21	ADD LOCKTITE	

RELEASED
05/08/15ISOMETRIC VIEW
SCALE 1:4

25163

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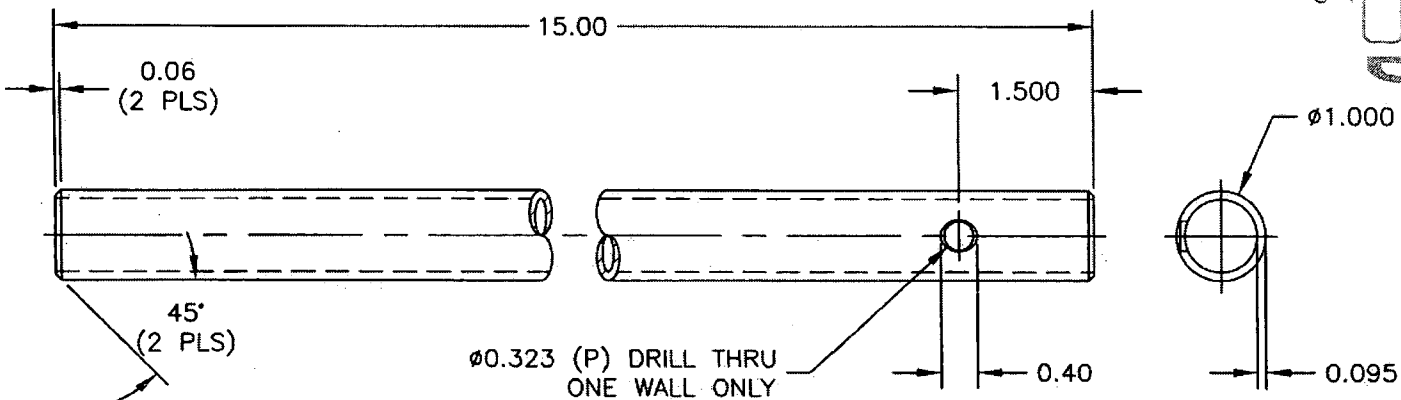
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	DRAWING NO.
DATE		D3380
05.07.21		TITLE
		GROUND HANDLING ASS'Y
		REV. B
		SHEET 2 OF 2
		SCALE
		1:2

RELEASED

05/08/15



D3380-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-1025 ROUND TUBING MILD STEEL SEAMLESS (REF. DART SPEC. M1018TR1.000)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 0005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

WORK ORDER
25163

FOR HAI 2005

05-01-26

P501-572

D044-733-041

QTY 1

D022-734-041

QTY 1

CPL CUT-15.250

M16332

1 1/4"

1.09

PIPE

CPL 15.00

M16332

1.00

.095

CPL

DEBURR

CPL

SQUISH and INSERT 1/4" PLATE

CPL

DRILL

(R.337)

(P.322)

(CHAMFER 100°)

← 2.50 →

CPL GRIND to R.45

↑ 1.25

CPL

WELD END OF PIPE

~~LACK PARTS TOGETHER IN JIG~~

CPL

LACK PARTS TOGETHER IN JIG

CPL

WELD

CPL

PAINT

CPL

ASSEMBLE RUBBER HANDLE → M16372

CPL

NYLON INSERT HEX NUT 1/2"-20 UNF → M16362
(.741 - .752" AF)

CPL

FINISHED HEX SAM NUT 3/4"-16 UNF → M16362
(1.1/8 AF X 27/64" THK)

CPL

R22 LOCK SHAFT PART# D3264-3 → M15267

CPL

R44 LOCK SHAFT PART# D3264-5 → M15267

CPL

SUPPORT PART# D3379 → M16332

CPL

D3264-1 → M16657

CPL

STICKER → B22246

CPL

SPRING M16372

CPL

PLASTIC WASHER

M

N/A R#05.01.26

